

Work Order ID 74831

74831

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Tuesday, October 11, 2011 9:23:31 AM

Item ID: D4001-1 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fitting
 Start Date: 10/11/2011 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 10/18/2011 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: mf Date: 11-10-13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4001	A								

100

0.00

100

Bandsaw

Jcaspa Bandsaw

Memo

cut blank 4.200" long

0.00

FK 11/11/10

6 0

110

0.00

110

HAAS 1

HAAS CNC vertical machine #1

Memo

MILL AS PER DWG AND FOLIO FA912

FOLIO REV: A

DWG REV: A

DEBURR

0.00

FK 11/11/10

6 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 10/11/2011 **Start Qty:** 6.00

6

Cust Item ID:

Required Date: 10/18/2011 Req'd Qty: 6.00

6

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID

Tool #**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

0.00

QC

Memo

Quality Control

130

QC8- Inspect parts - second check

0.00

130

0.00

QC

Memo

Quality Control

140

Identify as per dwg & Stock Location: 124

0.00

140

0.00

Packaging

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		.WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74831***74831***

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Tuesday, October 11, 2011 9:23:31 AM

Item ID: D4001-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fitting

Start Date: 10/11/2011 Start Qty: 6.00

6

Cust Item ID:

Required Date: 10/18/2011 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

11/11/14 *[Signature]*
mf
11-11-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, October 11, 2011 9:23:30 AM

Page 1

Work Order ID: 74831

Parent Item: D4001-1

Parent Item Name: Fitting

Start Date: 10/11/2011

Required Date: 10/18/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPPP REV:A NEW ISSUE 10-02-22 JLM VERIFIED BY:EC IPP rev B 10.05.13 ecn10-562 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X04.000 6061-T6 Bar 1.00 x 4.00		Purchased	No			100	f	18.8130	0.3501	2.2111579			

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT004	18.813	
114352	1	
116808	0.787	
118400	17.026	
119513		

2.2112

AK-10/11/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	24831
Description: Fitting		Part Number:	D4001-1
Inspection Dwg: D4001 Rev: A		Page 1 of 1	

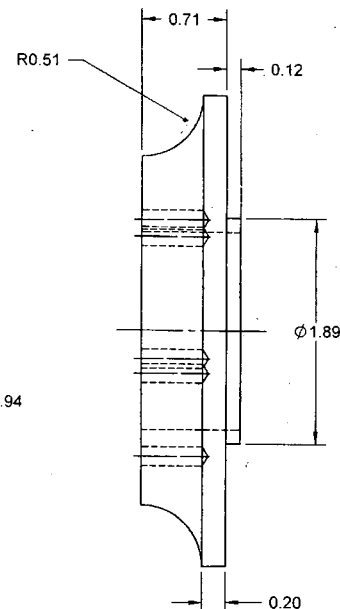
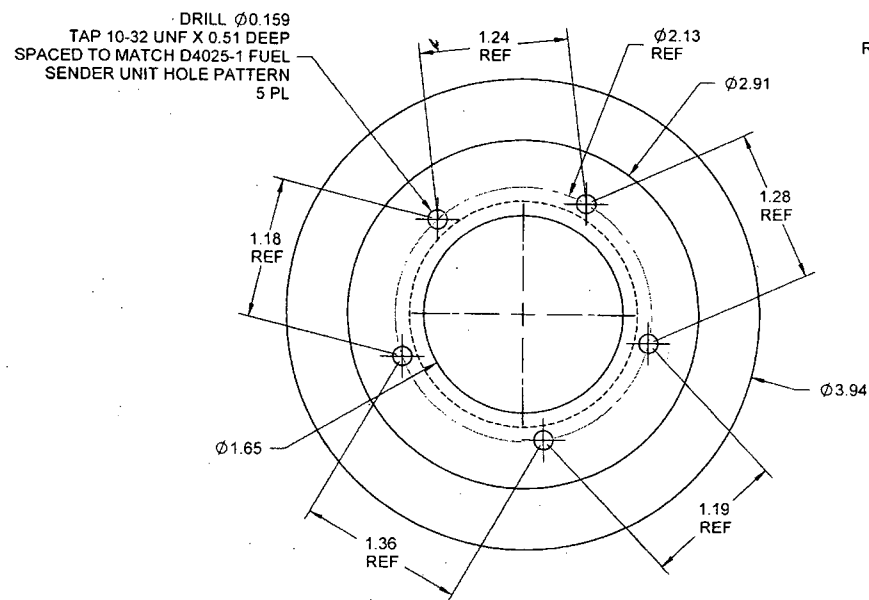
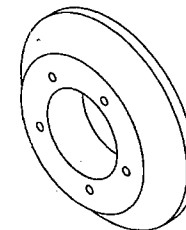
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.71	+/-0.030	.702	✓		FK-64	Vern.
0.12	+/-0.030	.127	✓		"	"
Ø1.89	+/-0.030	1.89	✓		"	"
0.20	+/-0.030	.190	✓		"	"
R0.51	+/-0.030	.51	✓		rad gauge	
Ø3.94	+/-0.030	3.936	✓		FK-64	Vern.
1.28	+/-0.030	1.28	✓		"	"
Ø2.91	+/-0.030	2.914	✓		"	"
1.24	+/-0.030	1.24	✓		"	"
10-32 UNF	N/A	10-32 whf	✓		checked with tap	
1.18	+/-0.030	1.18	✓		FK-64	Vern.
Ø1.65	+/-0.030	1.649	✓		"	"
1.36	+/-0.030	1.36	✓		"	"
1.19	+/-0.030	1.19	✓		"	"

Measured by: FK	Audited by: B.A	Preliminary Approval:
Date: 11/11/10	Date: 11/11/10	Date:

Rev	Date	Change	Revised by	Approved
A	11.03.08	New Issue	KJ	

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4001-1	JCA-M47-1-08



D4001-1 FITTING

RELEASED
2010-05-05

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF PART SPEC M6061T6R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.47 lbs

A	NEW ISSUE		10.02.05
REV.		DESCRIPTION	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. /
MFG. APPR.		D4001	SHEET 1 OF
APPROVAL		TITLE	
DE APPR.		FITTING	NTS
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